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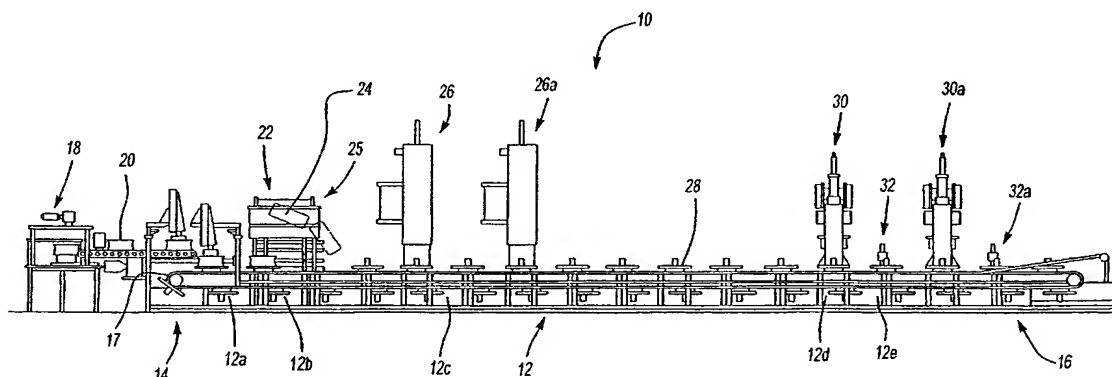
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(54) Title: ASSEMBLY LINE FOR MOUNTED UNITS



(57) Abstract: A tire assembly line (10) including a wheel soaping work station (18), a tire soaping workstation (22), a tire and wheel assembly station (26), and a tire inflation station (30). The assembly line is formed from a plurality of modules (12a, 12b, 12c, 12d, 12e) that are interchangeable and releasably connected to one another. The modules support an endless conveyor member (17) for circling movement. The endless conveyor member moves wheels and assemble tires and wheels along the assembly line between the work stations.